

film (20) so as to form gusset bags (1) in two rows to the left and right of said prescribed line (73).

By --25. (new) A manufacturing method of a gusset bag according to claim 23, wherein said side films (15, 23) form side surfaces (2c, 2d) of two gusset bags (1) located adjacent each other in front and back in the transfer direction of said flat films (12a, 12b).--

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Please charge the fee for three extra independent claims, namely, \$126, to the deposit account of the undersigned attorneys of record No. 25-0120.

R E M A R K S

The claims previously in the case have been replaced by a set of new claims which are believed to be proper as to form and patentable over the cited references.

Reconsideration is accordingly respectfully requested, for the rejection of the claims as anticipated by or unpatentable over BROENSTRUP 6,425,847, alone or in view of SULLIVAN 4,620,320.

There are a number of features of patentable novelty of the present method and apparatus, compared to the cited references.

For one thing, the side strips 15 of the present invention do not extend all the way across the longitudinal webs but rather stop short of at least one longitudinal edge thereof.

Another point of novelty is that the side strips have square ends and the boat shaped gusset is formed after application of the side strips to the longitudinal webs.

Still another feature of novelty is that the side strips stop short of the longitudinal edges and a zipper is applied between the end of the side strip and the longitudinal edge.

Still another feature of novelty is the line of sealing on the side of the zipper opposite the gusset of the side strip.

A still further feature of novelty is the mirror-image production of two side-by-side rows of bags, the two rows being finally separated along a cutting line such as CL in our drawings.

None of this is suggested by or made obvious by BROENSTRUP, whether alone or as modified by SULLIVAN. In BROENSTRUP, the side strips extend all the way across the longitudinal webs and are formed with their gussets in place before application to the longitudinal webs, as shown in Figs. 1-7 of BROENSTRUP. A modification of BROENSTRUP is shown in Fig. 8, in which the side strips have square ends, but the square ends extend all the way to the longitudinal edge of the webs.

SULLIVAN contains the broad teaching of the application of a zipper, but does not teach any modification of the structure BROENSTRUP by which the application of a zipper would bring BROENSTRUP into closer correspondence with the present invention as described above and as set forth in the new claims.

The other references of record, cited but not applied, are believed to be even more remote from the present invention that are those specifically discussed above, and so need not be discussed in greater detail at this time.

In view of the present amendment and the foregoing remarks, therefore, it is believed that this application has been placed in condition for allowance, and reconsideration and allowance are respectfully requested.

Attached hereto is a marked-up version of the changes made to the specification and abstract. The attached page is captioned "VERSION WITH MARKINGS TO SHOW CHANGES MADE."

Respectfully submitted,

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ABSTRACT OF THE DISCLOSURE

The present invention provides a manufacturing method and apparatus of a gusset bag, capable of coping with manufacture of various types of gusset bag and permitting improvement of productivity. A pair of flat films 12a and 12b are separated and transferred by a transfer unit 14, and a side film 15 extending in a direction perpendicular to the transfer direction of the flat films or in the same direction as the flat films and forming side surfaces 2c and 2d of the bag main body 2 is inserted between the pair of flat films 12a and 12b. The end of the side film is folded to form an open surface 43 at least at an end of the side film and the flat films. As a result, it is possible: (1) to manufacture a zippered gusset bag by attaching a zipper to the end of each flat film; (2) to manufacture a gusset bag having a flat bottom by attaching a bottom film to the end of each flat film; and (3) to manufacture a zippered gusset bag having a flat bottom by attaching a zipper to one end of each flat film, and a bottom film to the other end thereof.

**VERSION WITH MARKINGS TO SHOW CHANGES MADE**

Page 10, the second full paragraph, bridging page 11, has been replaced as follows:

The bottom 7 has a flat rectangular shape, and the four side of the outer periphery are fusion-sealed to the lower end of the bag main body 2. The side films 2a and 2b [has] have side tabs 6b at the lower ends thereof. The side tabs 6b are formed by folding outside the two sides 2c and 2d at a point on the crease as a base point. This folding step will also be described in detail later as to the step of forming the open surface. The bottom 7 is fusion-sealed to this side tabs 6b. In Fig. 2 showing the state in which the gusset bag is folded, the bottom is V-shaped.--

Page 11, the second full paragraph has been replaced as follows:

--A material fed from a material roll 11 is pulled out by a payoff roll, and the material vertical posture is changed by a turn bar into a horizontal posture. The material is cut at the center into two halves which are separated into a pair of upper and lower flat films 12a and 12b. These [pair of] flat films 12a and 12b form flat surfaces 2a and 2b in two left and right rows of the bag main body 2. In other words, the flat films 12a and 12b are transferred by a transfer unit 14 composed of a feed roller 13 and the like in such a manner that the flat films 12a

and 12b opposed to each other in a vertical direction [forms] form the front surface and the back surface of a bag. The materials are fed [in secession] continuously. However, the flat films are intermittently sent by a step roller or the like not shown in the subsequent steps, and other operations are carried out during the period when the intermittently sent flat films stop.--

Page 12, the last paragraph, bridging page 13, has been replaced as follows:

--In the above-mentioned embodiments, the side film 15 is inserted in a direction perpendicular to the transfer direction of the flat films 12a and 12b. However, the side film 15 may be inserted, as shown in Fig. 7, in the same direction (arrow direction 2 in Fig. 7) as the transfer direction (arrow direction 1 in Fig. 7) of the flat films 12a and 12b. The side film 15[,] is not adhered to the lower flat film 12b, but may be adhered to the upper flat film 12a. Furthermore, when the side film 15 is formed by two V-shaped films 15a and 15b, the V-shaped films 15a and 15b may be temporarily adhered to the upper flat film 12a and the lower flat film 12b, respectively, spaced apart from each other by an appropriate distance so as to form side surfaces 2c and 2d of the bag main body 2 transferred front and back when placing the pair of flat films 12a and 12b opposed to each other.--